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D119-646-24
Job Sheet 181635



Part No: D119-646-241

Job Qty: 1 ea

Part Name: AW119 Replacement Skidtube with Heavy Duty Wearplates - Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/2/18

Job Tracking No:

Due Date: 8/13/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *STOK*

Description:

Note: DWG IIN-D119-646 REV D, D3887-045 REV E SHEETS 4, 6-11 IPP RevA: New issue DD verified by:EC IPP REV B 12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf.JLM IPP REV:C 13.03.20 per chg003 ECN13-534 DD verf.JLM IPP REV:D 17.05.19 as per dwg D3887 rev.e DD verf.JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/13/18	8/13/18	0.00	0.00	Start Up Skid tubes-1		<i>Jy</i>
110	Skid tubes	1 pcs	8/13/18	8/13/18	0.77	0.05	Skid tubes-1		<i>Jy</i>
120	HandFinish	1 pcs	8/13/18	8/13/18	0.00	0.79	HandFinish1		<i>DR 18/08/20</i>
121	QC	1 pcs	8/13/18	8/13/18	0.00	0.00	QC7-1		<i>MGR</i>
122	QC	1 pcs	8/13/18	8/13/18	0.00	0.00	QC5		<i>BE</i>
130	Skid tubes	1 pcs	8/13/18	8/13/18	0.00	2.38	Skid tubes-1		<i>BE</i>
135	QC	1 pcs	8/13/18	8/13/18	0.00	0.00	QC5		<i>BE</i>
140	Skid tubes	1 pcs	8/13/18	8/13/18	0.00	2.38	Skid tubes-1	<i>*1-2</i>	<i>MGR</i> <i>DAS</i> <i>MGR</i>
150	QC	1 pcs	8/13/18	8/13/18	0.00	0.00	QC5		<i>BE</i> <i>38</i>
160	Skid tubes	1 pcs	8/13/18	8/13/18	0.00	2.44	Skid tubes-1		<i>BE</i> <i>9-89</i> <i>0.00</i>
170	QC	1 pcs	8/13/18	8/13/18	0.00	0.00	QC5		<i>BE</i> <i>38</i>
180	QC	1 pcs	8/13/18	8/13/18	0.00	0.00	QC10		<i>38</i> <i>9-89</i>
190	HandFinish	1 pcs	8/13/18	8/13/18	0.00	0.33	HandFinish2		<i>DR 18/09/12</i>
200	Powdercoat	1 pcs	8/13/18	8/13/18	0.00	0.20	Powdercoat1		<i>BE</i> <i>13-9-19</i>
210	QC	1 pcs	8/13/18	8/13/18	0.00	0.00	QC3		<i>BE</i> <i>18-9-19</i>
240	HandFinish	1 pcs	8/13/18	8/13/18	0.00	0.79	HandFinish4		<i>BE</i> <i>18-9-19</i>
250	QC	1 pcs	8/13/18	8/13/18	0.00	0.00	QC5		<i>SEP 20 2018</i> <i>DAS</i> <i>68</i>
258	DC	1 pcs	8/13/18	8/13/18	0.00	0.00	DC		<i>SEP 20 2018</i> <i>9-89</i>
260	Packaging	1 pcs	8/13/18	8/13/18	0.00	0.00	Packaging3-1		<i>APR 15 2019</i> <i>9-89</i>
270	QC21-FG	1 Ea	8/13/18	8/13/18	0.00	0.00	QC21		<i>APR 15 2019</i> <i>9-89</i>

Part Op 110 - 1- inspect Mat'L D2500-1-190 for damage 2-Cut tube to length as per dwg D3887 (154.8") 3- Ensure squareness of Descriptions: ends and scribe batch#

130 - 1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only. 2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes. 3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes using DT9477 4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes*** 5- Deburr, blow out chips from inside of tube. 6- Bond web in place as per Dwg D3887 & QSI 015. A/R Sikaflex-291 *9-89* Sikaflex expire date: *2019/03/06* Start: _____ Time: _____ Finish: _____ Time: _____ ***** (Adhere for 12 hours) *****

140 - 1- Bend FWD end of tube using bender 1 and bend prog. D3887.***Must use bending aid DT9544, ensure proper positioning*** 2- Cut FWD end of tube as per dwg D3887.***Verify measurement*** 3- Buff out marks left from bending 4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" 5- Open FWD saddle holes to finished size as per dwg D3887 6- Drill FWD x-bolt spacer holes using DT9816 and open to finished size.(verify measurement) 7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify measurement). Open to finished size. 8- Drill 1.87"

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Container No: S103433



Part: D119-646-241

Job No: 181635

Serial No/Batch: S103433

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 15/10/2016 TC STC LoA P-09-0407-RDIMS-

and 3.74 holes using DT10045 A&B locate from FWD saddle hole. (verify measurement) as per dwg. 9- C'sink FWD cap hole as per detail "C" 10- Countersink crossbolt spacer holes, and prepare tube for welding, deburr. 11- Deburr and blow out chips from inside of tube.

160 - NOTE: TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDLING FIXTURE, IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091. 1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/R Aluminum Rod 138834 2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole. 3-Counterbore x-bolt spacer holes as per Dwg D3887 using DT10279. 4-Deburr and blow out chips from inside of tube 5- Pick D2855-5 cap and transfer drill missing hole. Deburr and identify cap with skidtube batch#.

170 - TEST FIT USING FIXTURE DT10091.

200 - ***MASK AREA SHOWN ON SHEET 7, NOTE 9*** START TIME: 8:15 OVEN TEMPERATURE: 320° FINISH TIME: 9:45 MS55B.

240 - 1-Install wearplates as per Dwg D3887. 2 -Inspect for foreign objects as per QSI 024 3 -Install D2855-3 Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 1438970 Sikaflex expire date: 16-9 4 -Install insert in D2855- Cap. Install cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 1438970 Sikaflex expire date: 16-6 5- INSPECT TORQUE ON BOLTS AS PER DWG.

BY: DATE: 6-Wing Walk as per dwg QSI005 4.4 Batch: 1438970

258 - Photocopy bluefile & type labels per PPP D119-646-241 CHG005

260 - Location : FG084

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-1-190	Ext'n - I' Beam Tube 4"	1 Ea (1 ea)	90-Start up Operation	508001
D2579	Crossbolt Spacer	2 Ea (2 ea)	140-Skidtubes	5031552
D3885-1	Standard Web	1 Ea (1 ea)	140-Skidtubes	5083677
D3681-1	Spacer	12 Ea (12 ea)	160-Skidtubes	5084724
D3903-1	Spacer	12 Ea (12 ea)	160-Skidtubes	5084655
ALS4-1032-225	Rivnut	1 Ea (1 ea)	240-HandFinish	5058138
AN3C46A	Bolt	8 Ea (8 ea)	240-HandFinish	5095390
AN3C5A	Bolt	2 Ea (2 ea)	240-HandFinish	5095214
D2855-3	Cap	1 Ea (1 ea)	240-HandFinish	5066002
D2855-5	Cap	1 Ea (1 ea)	240-HandFinish	5002078
D3492-045	Plug Assembly	8 Ea (8 ea)	240-HandFinish	5040473
D3672-1	Washer, Phenolic	2 Ea (2 ea)	240-HandFinish	F163250-8
D3849-041	Fwd Heavy-Duty Wearplate, Std Skid Compatible	1 Ea (1 ea)	240-HandFinish	5010699
D3849-043	Aft Heavy-Duty Wearplate, Std Skid Compatible	1 Ea (1 ea)	240-HandFinish	5074173
D3904-1	Washer	16 Ea (16 ea)	240-HandFinish	5105379
MS21043-3	Nut	8 Ea (8 ea)	240-HandFinish	5083543
MS24694-C52	Screw	2 Ea (2 ea)	240-HandFinish	5067269
NAS1149C0332R	Washer	2 Ea (2 ea)	240-HandFinish	5071663

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-190	1	23	0
140-Skidtubes	D2579	2	225	0
	D3885-1	1	19	0
160-Skidtubes	D3681-1	12	130	0
	D3903-1	12	118	0
240-HandFinish	ALS4-1032-225	1	3,602	0
	AN3C46A	8	193	0
	AN3C5A	2	2,897	0
	D2855-3	1	20	0
	D2855-5	1	74	0
	D3492-045	8	44	0
	D3672-1	2	1,018	0
	D3849-041	1	4	0
	D3849-043	1	5	0
	D3904-1	16	162	0
	MS21043-3	8	752	0
	MS24694-C52	2	175	0
	NAS1149C0332R	2	5,054	0

Part Specifications

Specifications could not be found.

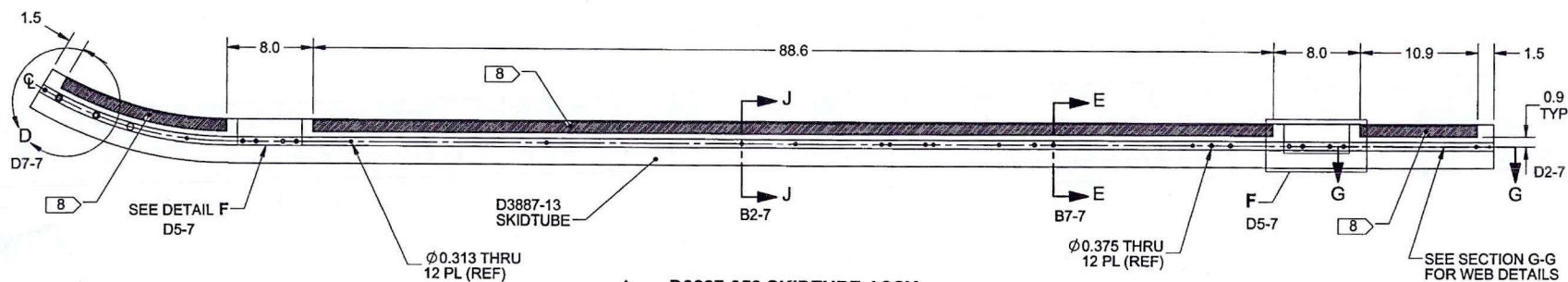
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ITEM	QTY -053	P/N	DESCRIPTION
	X	D3887-053	SKIDTUBE ASSY
1	2	D2579	CROSS BOLT SPACER
2	12	D3681-1	CROSS BOLT SPACER
3	1	D3885-1	STANDARD WEB
4	1	D3887-13	SKIDTUBE
5	12	D3903-1	CROSS BOLT SPACER



D3887-053 SKIDTUBE ASSY
(WELDING DETAIL)

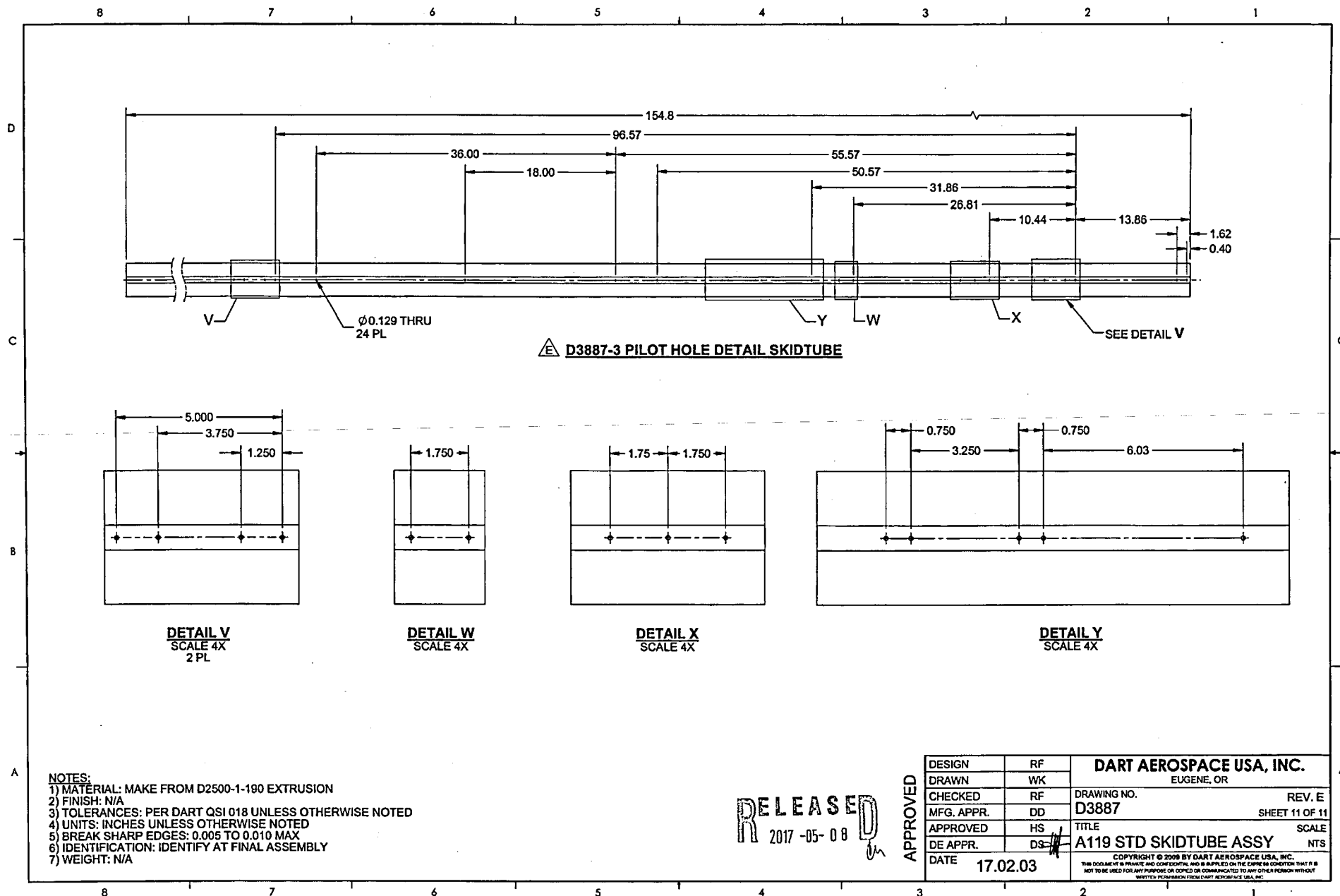
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50 ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

RELEASED
2017-05-08

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	WK	EUGENE, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3887	SHEET 6 OF 11
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 STD SKIDTUBE ASSY	NTS
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Part Number:	D119-646-241
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Description:	REPLACEMENT STD SKIDTUBE w/ TRAINING WEARPLATES
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